

Work Order ID 123236

August-01-14 8:21:41 AM

123236

Page 1

Item ID: D4072-1

Accept

N19000040100

Setup Start

NS1

Revision ID:

Item Name: Airframe Hinge

Stop

NS2

Start Date: 8/01/14 Start Qty: 16.00

16

Cust Item ID:

Required Date: 8/08/14 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4072

B

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT 1.250" LONG

16

Ø

DAS
20
9-89

14-08-06

105

0.00

105

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Mill as per Dwg an Folio FA938

Dwg Rev: B

Folio Rev: AA

16

SL 14-8-7

DAS
20
9-89

14-08-06

Deburr

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Item ID: D4072-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Airframe Hinge
 Start Date: 8/01/14 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							JL 11-8-7 DAS 20 9-89 14-08-06
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				16	0		DAS 44 14/05/08 9-89
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				16		14-08-11	DAC

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Item ID: D4072-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Airframe Hinge
 Start Date: 8/01/14 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 128959 Memo s 135 OT 320 F 205	0.00 Aluminum MK				16			DAS 41 9-89 14-8-11
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				16	0	(2P)	14/08/12
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: 57085 Memo	0.00				16X			DAS 28 9-89 AUG 12 2014

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Item ID: D4072-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Airframe Hinge
 Start Date: 8/01/14 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 8/08/14 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 14-08-12
MLJ 14-08-12

Picklist Print

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Page 1

Work Order ID: 123236

123236

Parent Item: D4072-1

D4072-1

Parent Item Name: Airframe Hinge

Start Date: 8/01/14

Required Date: 8/08/14

Start Qty: 16.00

Required Qty: 16.00

Comments:

Ipp Rev:A New Issue 10-06-09 JLM Verified By:DD
REV:B DRAWING REV. CHANGE AS PER ECN 11-598
VERIFIED BY:

IPP
11-07-05 JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.50 0		Purchased	No			100	f	7.3354	0.104	2			

M6061T6B1 000X02 500
6061-T6 Bar 1.00 x 2.50

1.833'

DAS
20
9-89

14-08-06

Location

Loc Qty

Loc Code

MAT003

7.3354

124443

0.749

125386

0.8

M128437

5.7864

1.833'

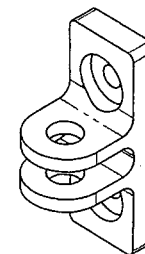
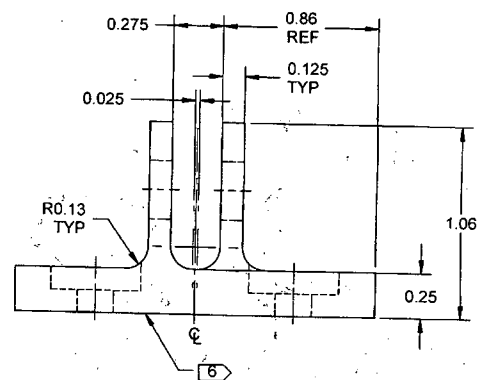
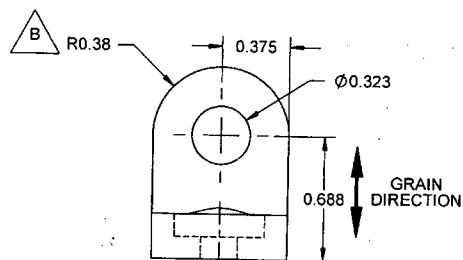
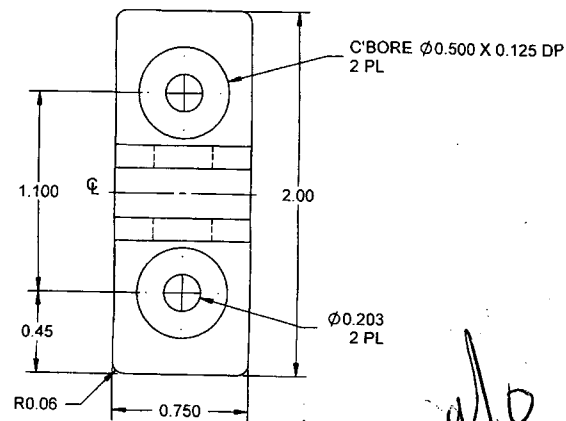
DART AEROSPACE LTD		Work Order: 123236
Description: Airframe Hinge		Part Number: D4072-1
Inspection Dwg: D4072	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.500 x 0.125	+/-0.010	.502 x .126	✓		SLO8	Vein
2.00	+/-0.030	.201	✓			
Ø0.203	+0.005/-0.001	.204	✓		Gauge	PIN
0.750	+/-0.010	.751	✓			
R0.06	+/-0.030	.060	✓			
0.45	+/-0.030	.445	✓		Rad gauge	
1.100	+/-0.010	1.099	✓			
R0.38	+/-0.030	.380	✓		Rad gauge	
0.375	+/-0.010	.374	✓			
0.688	+/-0.010	.687	✓			
0.275	+/-0.010	.273	✓			
R0.13	+/-0.030	.130	✓		Rad gauge	
0.25	+/-0.030	.248	✓			
1.06	+/-0.030	1.061	✓			
0.125	+/-0.010	.126	✓			
0.86	+/-0.030	.863	✓			
Ø0.323	+0.005/-0.001	.324	✓		Gauge	PIN

Measured by: DAS 20 9-89	Audited by: DAS 44 9-89	Preliminary Approval:
Date: 14-08-06	Date: 14/08/08	Date:

Rev	Date	Change	Revised by	Approved
A	11.06.26	New Issue	KJ	
B	11.10.13	Dimension 0.25 removed	KJ	



D4072-1 AIRFRAME HINGE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED
2011-06-30

B	CORRECT TYPO (ZN B7-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DRAWING NO. D4072	
DATE	10.11.02	TITLE AIRFRAME HINGE	
		SCALE NTS	
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